

Work Order ID 155308-2

Thursday, January 12, 2017 10:53:43 AM

155308-2

Page 1

Item ID: D3862-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearplate Weldment

Start Date: 1/17/2017 Start Qty: 12.00

12

Cust Item ID:

Required Date: 1/24/2017 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan:

Date: JAN 12 2017

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

d3862

REV A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.80

FLOW CNC Waterjet

1-Cut as per Dwg D3862Dwg Rev: 1 Prog Rev: 1 2-Deburr
if necessary

(13)

1/17/2017

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.02

Quality Control

(13)

1/17/2017

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.04

Quality Control

13

DAS
38
8-89

JAN 17 2017

Work Order ID 155308***155308***

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Page 2

Item ID: D3862-041**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Wearplate Weldment**Start Date:** 1/17/2017 **Start Qty:** 12.00***12*****Cust Item ID:****Required Date:** 1/24/2017 **Req'd Qty:** 12.00***12*****Customer:****Reference:****Approvals:****Process Plan:****Date:****Tooling:****Date:****Run Start *NR1*****QC:****Date:****SPC (Y/N):****Date:****Stop *NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

130

0.00

130

Large Fab

Large Fab

Memo

0.92

1-Weld D3009-3 cups as per dwg D3862

A/R 316L stainless steel rod Batch: M134412

2-Weld hard facing as per Dwg D3862

A/R 2059B Hard Coat rod Batch: M130145

*****use D19464 for welding*****

140

QC9- Inspect visual per QSI004- Fusion Welds

0.00

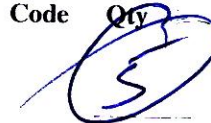
140

QC

Memo

0.00

Quality Control



DYC

5 Q.L 17-03-27

⑤ 17-03-28 80

Work Order ID 155308

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Page 3

Item ID: D3862-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate Weldment

Start Date: 1/17/2017 Start Qty: 12.00

12

Cust Item ID:

Required Date: 1/24/2017 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.04

Quality Control

⑤ 17-03-28 70.

160

Grey Sandtex (Ref: 4.3.5.6) per QSI005 4.3

0.00

160

Powdercoat

Memo

0.06

Powder Coating

START TIME:

1:15

OVEN TEMPERATURE:

320° FINISH TIME:

1:45

5 17-03-28 33.88

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.02

Quality Control

5

DAS
38
9-88
MAR 28 2017

Work Order ID 155308

Thursday, January 12, 2017 10:53:43 AM

155308

Item ID: D3862-041

Revision ID:

Item Name: Wearplate Weldment

Start Date: 1/17/2017

Start Qty: 12.00

12

Required Date: 1/24/2017

Req'd Qty: 12.00

12

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

180

180

Packaging

Packaging

Memo

0.02

Set Up/
Run Hours

0.00

Identify as per dwg & Stock Location: ST193

DAS
6
9-89

5

DAS
41
9-89

MAR 30 2017

190

190

QC

Quality Control

Memo

0.20

QC21 - Final Inspection - Work Order Release

0.00

17-3-31
me

17/4/3

Picklist Print

Thursday, January 12, 2017 10:53:42 AM

Page 1

Work Order ID: 155308

155308

Parent Item: D3862-041

D3862-041

Parent Item Name: Wearplate Weldment

Start Date: 1/17/2017

Required Date: 1/24/2017

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 09-02-03 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	110.5700	0.9	10.8			
M304S16GA									**	3.25		01/17/2017	
304/316 Sheet .063													

Location	Loc Qty	Loc Code
MAT010	110.57	
m134604	5	
m136036	34.97	
m136327	70.6	

D3009-3

Manufactured No

D3009-3

Cup

130 Each 89.0000 6

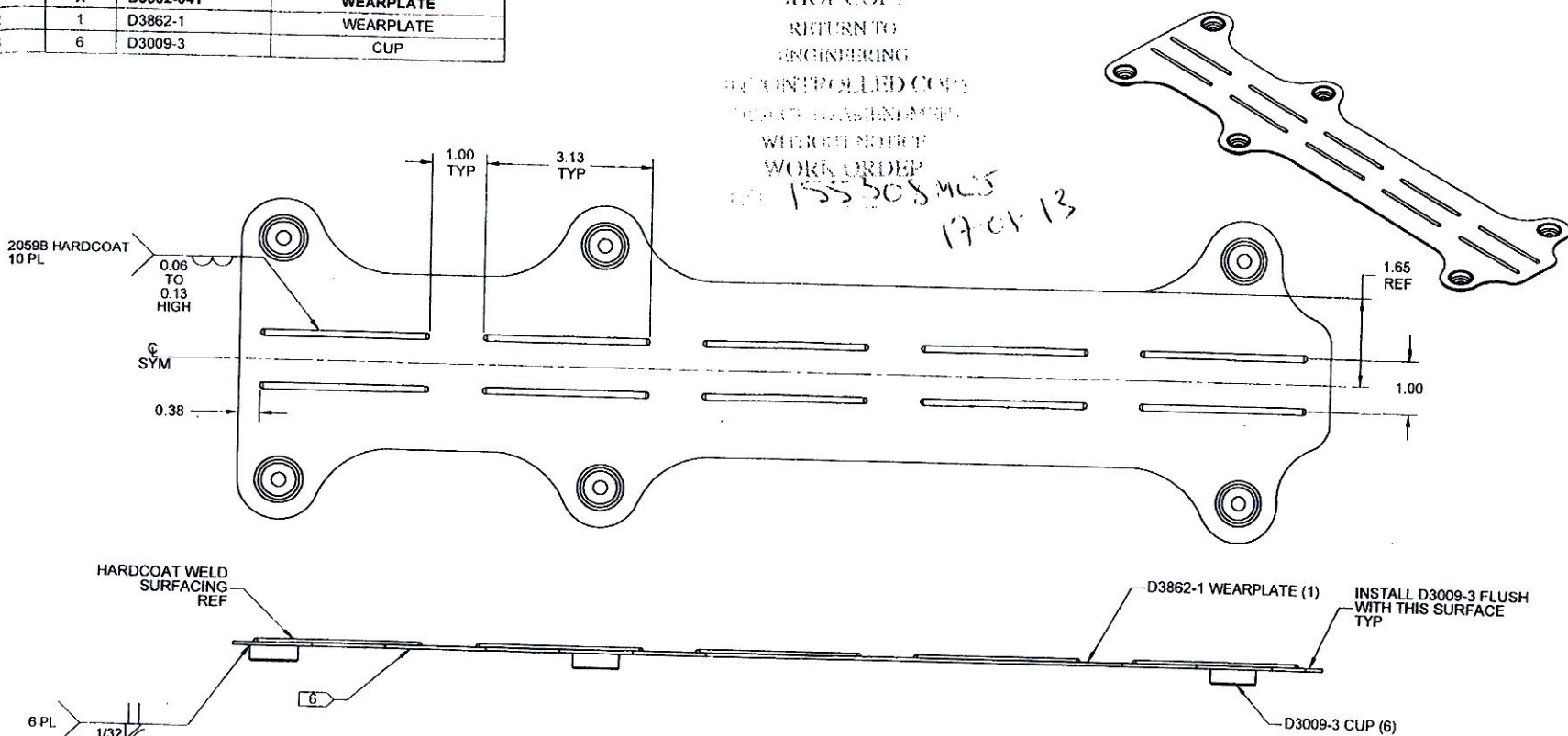
OK 17/03/23

Location	Loc Qty	Loc Code
WA001	20	
154817	20	
WA002	69	
152430	9	
154963	60	

B156118 30x

ITEM NO.	QTY. .041	PART NUMBER	DESCRIPTION
1	X	D3862-041	WEARPLATE
2	1	D3862-1	WEARPLATE
3	6	D3009-3	CUP

XERO COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 WORK ORDER
 155308 M05
 17-01-13



D3862-041 WEARPLATE

RELEASED
#09.01.21

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3862-041" & B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 1.56 lbs
 - 8) WELD PER DART QSI 004

A NEW ISSUE		BY	DATE
REV.	DESCRIPTION		
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.01.21		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3862	REV. A
TITLE WEARPLATE	SHEET 1 OF 2
SCALE NTS	
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